

Grey

Dart Aerospace Ltd.

Date: Tuesday, 10/02/2009 3:10:04 PM  
 User: eulie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE  
 Job Number : 45733  
 Estimate Number : 13769  
 P.O. Number :  
 This Issue : 10/02/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D3860041  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3860 REV.A  
 Previous Run : 45475 Drawing Revision : A  
 Material :  
 Due Date : 28/02/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : JWD 09.02.10  
 Comment : Est Rev:A 09-02-03 new issue DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 0.4780 sf(s)/Unit Total : 1.9118 sf(s)

304/316 .063 Sheet

Batch: 110551

ml 09 02 25

(4)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3860

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

ml 09 02 25

(4)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 02 25



(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S. 09/02/25

(x4)

5.0 D30093 Cup



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

CUP

Batch: 42376

BE 09/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:10:04 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45733

Part Number: D3860041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3860

A/R 316L stainless steel rod

Batch:

2-Weld hard facing as per Dwg D3860

A/R 2059B Hard Coat rod

Batch:

\*\*\*\*\*use DT9462 for welding\*\*\*\*\*

*m109263 BE 09/03/10*

*M11036 EL 9-4-28*

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 09-04-28 (4)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*8 09/04/28 (44)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*11:20*

*320°*

*11:50*

*CMD/EL*

*09/04/30*

*(44)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-04-30*

*(44)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker as indicated on dwg, then Stock

Location:

*7-497*

*9/5/11*

*SV*

*(44)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/02/2009 3:10:04 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45733

Part Number: D3860041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/04 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

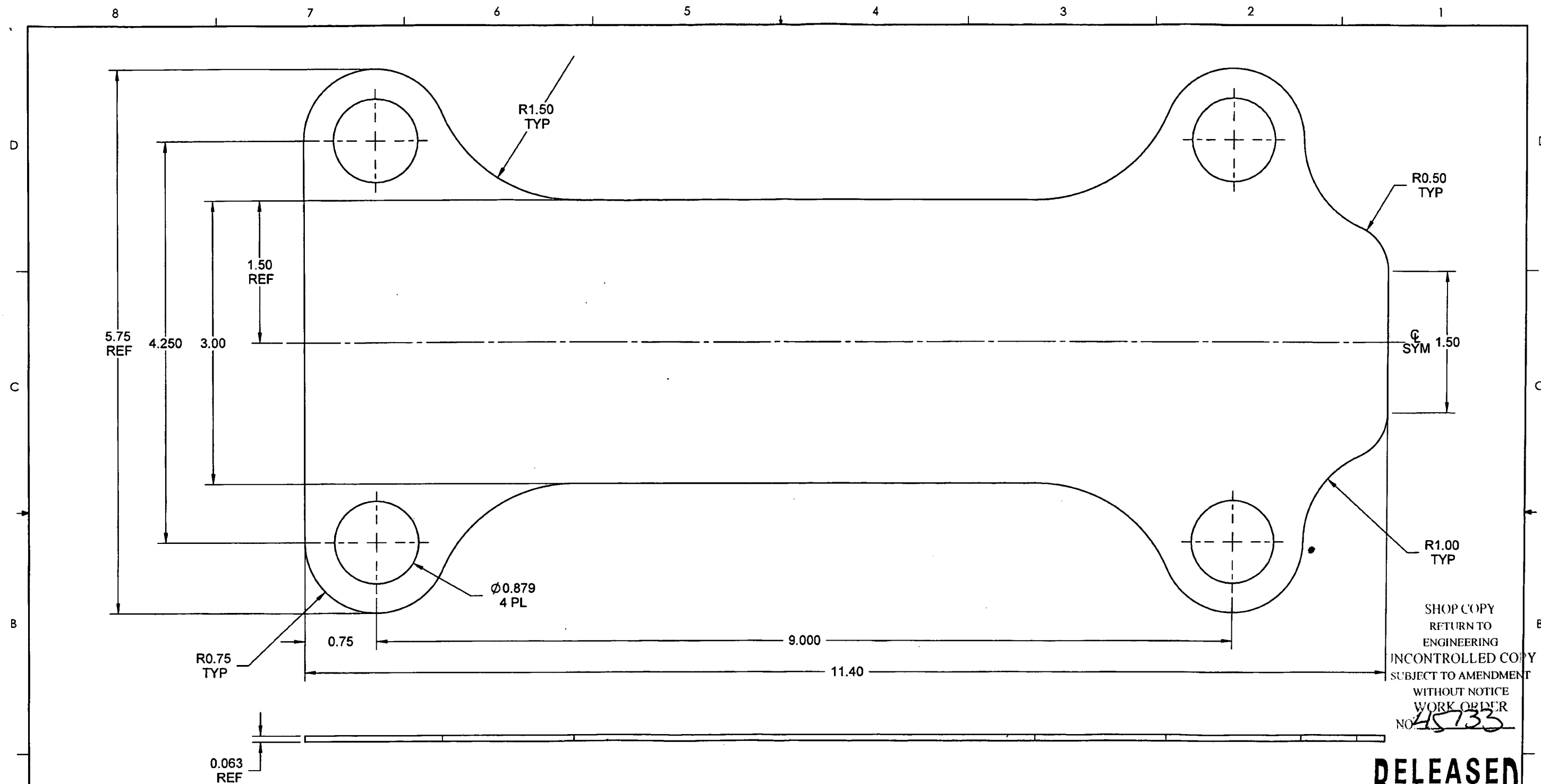
# FIRST ARTICLE INSPECTION CHECKLIST

**X**

**x**













# D3860-1 WEARPLATE

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.73 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3860	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	09.01.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			